

Date: Tuesday, 1/23/2007 7:31:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 6" MIRROR		
Job Number	: 30376		Part Number	: D2011101		
Estimate Number	: 10101		Drawing Number	: D2011 REV. F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/23/2007 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/29/2007		
Previous Run	: 29773		Qty:	50	Um:	Each
Written By	: <i>[Signature]</i>		Comment	: Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white EC		
Checked & Approved By	: <i>[Signature]</i> 01.01.23		KJ/JLM			
Comment	: Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING <i>(2929) 01/01/24 (50)</i>
2.0	28043	MIRROR 6" <i>(28043) 01/01/24 (50)</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>(28043) 01/01/24 (50)</i>
4.0	QC6	DIMENSIONAL CHECK <i>(28043) 01/01/24 (50)</i>
5.0	D30141	Locknut <i>(D30141) 01/01/24 (50)</i>

Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

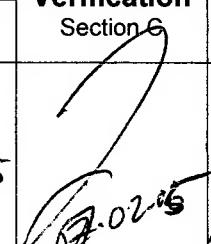
Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached
(28043) 01/01/24 (50)

Comment: DIMENSIONAL CHECK
(28043) 01/01/24 (50)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut
 Pick:
 Qty Part Number Description Batch
 1 D3014-1 Lock nut *m18605* *MF 07-02-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/05	7	I mirror broke when hole were drill  QSI0102		Scrap & destroy	SB 07/02/05  07.02.05			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 30376

Part Number: D2011101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416L	Washer	m101237

MF. 07-02-02

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

MF. 07-02-02

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

MF. 07-02-02

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291/-241	m100692

MF. 07-02-02

Expiry date 02/07

07/02/01

Start: 1:05 Time: 1:05

Finish: 07/02/02 Time: 7:30

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

SP. 07/02/05

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST199

J. Bay/02/05 49 R 7/02/05

49

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 07/02/06

Job Completion



✓ 07/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

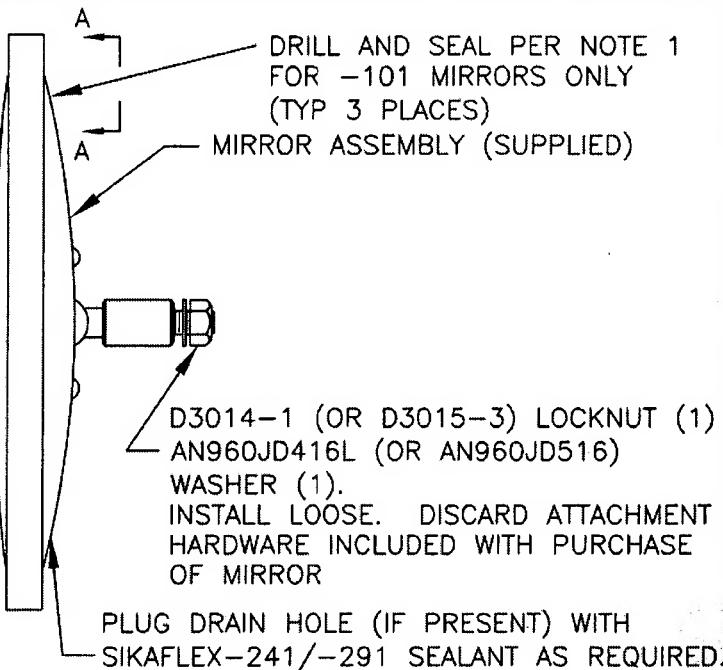
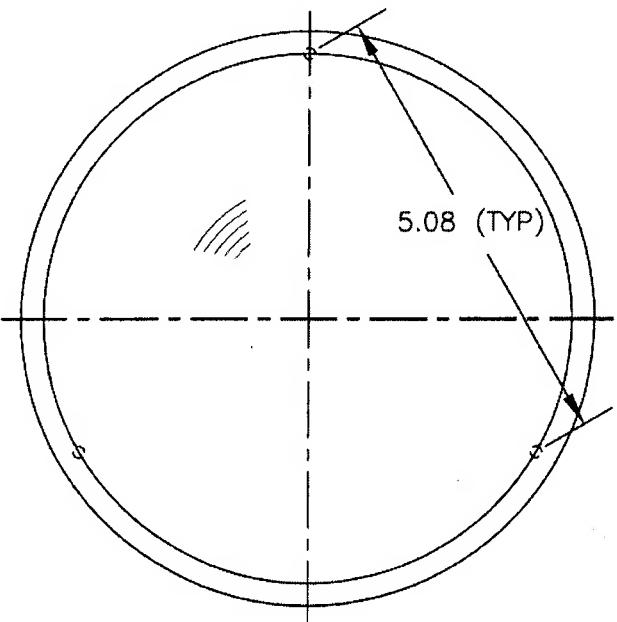
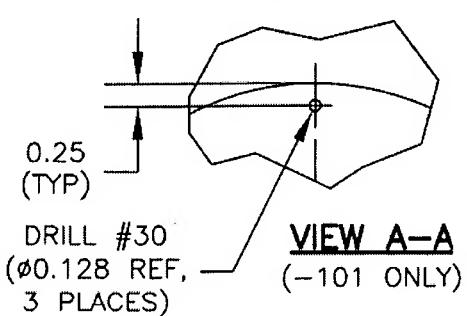
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY ISSUED
TO DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2

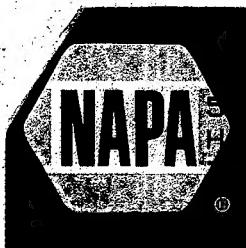
RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST WORK ORDER NO. 30316
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



WAKESBURY AUTO PARTS INC 5580GST#: 861597896RT0001
 4 MAIN STREET WEST EXC#: SU 6259 EXP: 03/12/31
 WAKESBURY, ONT. K6A 2J2 DANGEROUS GOODS PERMIT
 :632-8575 FAX: 632-1539 EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
 CANUTEC 613-996-6666

ACCT #	SOLD TO		DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		1/29/07	14:20	060004074	31	148348
SR #			PURCHASE ORDER #		ATTENTION		
6			2929				
AD			TAX EXEMPTION: 6122-5207		TERMS:		
EE			NET 30 DAYS		CHARGE SALE		
DELIVERY:							
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL	
28043	GR	GRUTE	50.00	41.140	16.520	841.00	

REFUNDED BY _____ Subtotal 841.00
 VERIFIED BY _____ Tax 6% GST ONLY 50.46
 _____ Tax 0% 0.00

Emile Bauer

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE

891.46

Comments:	Tax Summary:		
	GST	50.46	Less: included tax
	GSTME	0.00	
	GSTND	0.00	
	Subtotal	841.00	
	Total tax	50.46	
Entered By: <i>CL</i>	CLAVOIE	Total purchase order in	
Approved By: _____	CAD Dollars	891.46	